

Date: Friday, 28/11/2008 2:54:33 PM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: SADDLE SPACER		
Job Number	: 43857			Part Number	: D2877		
Estimate Number	: 10827			Drawing Number	: D2877 REV B		
P.O. Number	:			Project Number	: N/A		
This Issue	: 28/11/2008	S.O. No.	:	Drawing Revision	: B		
Prsht Rev.	: NC			Material	:		
First Issue	: / /	Type	: SMALL /MED FAB	Due Date	: 20/12/2008		
Previous Run	: 39125			Qty:	60	Um:	Each
Written By	:						
Checked & Approved By	: <u>JUL 08-12-01</u>						
Comment	Est B 00.05.19 Added inspect level 8 EC Est C 06.04.26 Water jet EC Est Rev:D Now M6061-T6 06-06-23 JLM Est Rev:E Updated Thickness as per Rev B 06-09-18 JLM						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6S125	6061-T6 .125 Sheet
Comment: Qty.: 0.0637 sf(s)/Unit Total : 3.8241 sf(s) Material: 6061-T6 (QQ-A-250/8) 0.125" Thick Batch: <u>109058</u> <u>B 8-12-11</u>		
2.0	WATER JET	FLOW WATER JET
Comment: FLOW WATER JET 1-Cut as per Dwg D2877 Dwg Rev: <u>B</u> <u>B 8-12-11</u> Prog Rev: <u>B</u>		
2- deburr <u>B 8-12-11</u>		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
<u>B 8-12-11</u>		
Comment: INSPECT PARTS AS THEY COME OFF MACHINE		
4.0	QC8	SECOND CHECK
<u>S 08/12/11</u> <i>coconuts</i> <u>CE00</u>		
Comment: SECOND CHECK		
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
<u>SMALL & MEDIUM FAB RESOURCE 1</u>		
<i>Deburr if necessary</i> <i>n/n</i> <i>Done at step # D.2</i> <i>8-12-11</i>		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Seq. #: Machine Or Operation:

Description :

6.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



80x

Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

M-1 08/12/12

7.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



8/12/12



SP 80x

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

8.0 PACKAGING 1

PACKAGING RESOURCE #1



80x

Comment: PACKAGING RESOURCE #1

Identify and Stock
Location: SC

8/12/12

SP

9.0 QC21

FINAL INSPECTION/W/O RELEASE



08/12/15 JG

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



u 8.12.15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	43851
Description: Saddle Spacer	Part Number:	D2877
Inspection Dwg: D2877	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	<u>BS</u>	Audited by:	<u> </u>	Prototype Approval:	N/A
Date:	8-12-11	Date:	08/12/11	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.01.21	New Issue	KJ/RF	
B	06.06.23	Dwg Rev. changed	KJ/JLM	JL

DART

DESIGN <i>CP</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>MM</i>	DRAWING NO. D2877	REV. B SHEET 1 OF 1
DATE 06.05.17		TITLE SADDLE SPACER	SCALE 1:1
A	99.02.23	NEW ISSUE	
B	06.05.17	THICKNESS WAS 0.100", MAT CHANGE	

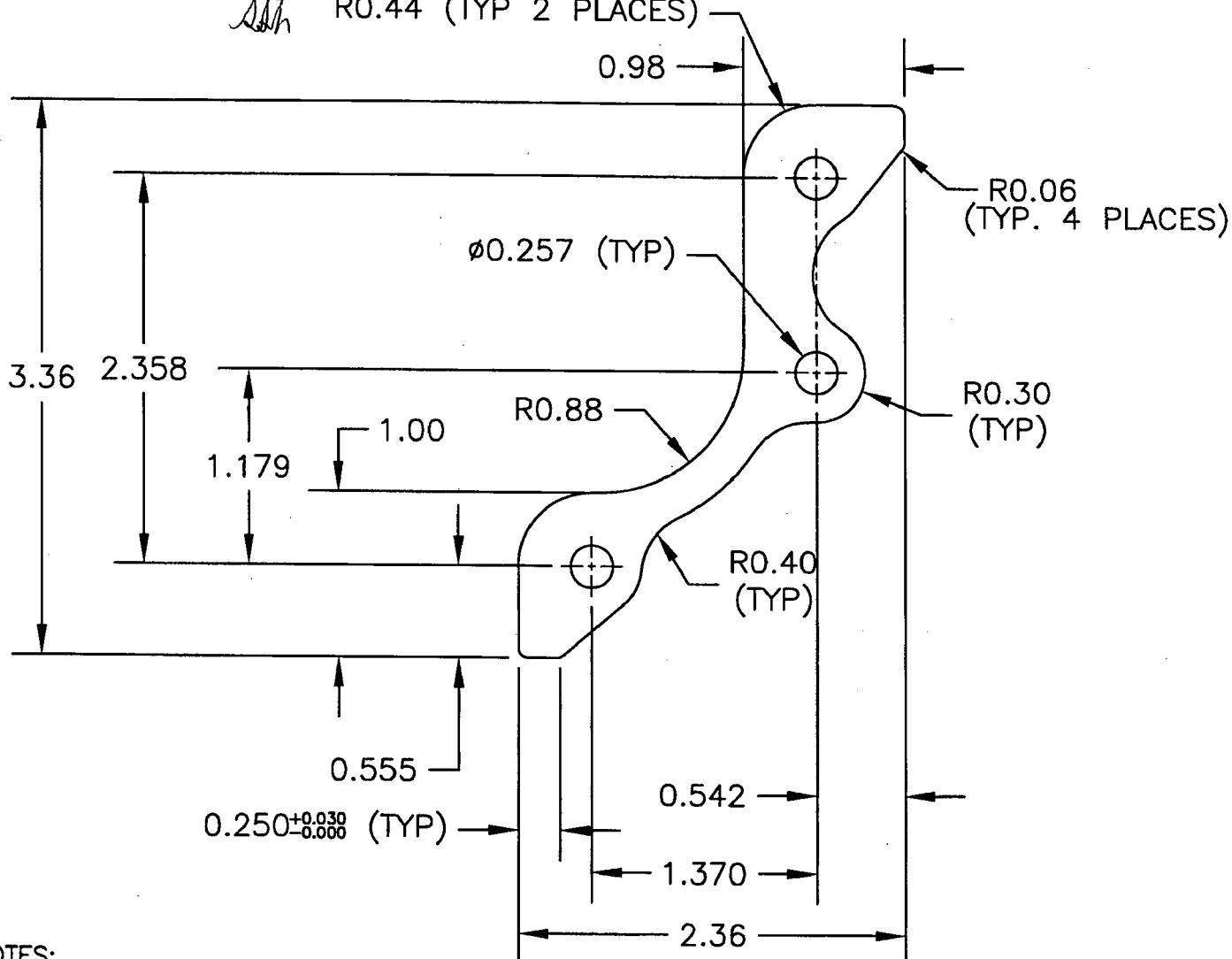
RELEASED

06.06.21

AS PER ECR 813

SMH

R0.44 (TYP 2 PLACES)

NOTES:

- 1) MATERIAL: 6061-T6 ALUMINUM SHEET (QQ-A-250/11) 0.125" THICK
(REF DART SPEC M6061T6S.125)
OR
5052-H32/H34 ALUMINUM SHEET (QQ-A-250/8) 0.125" THICK
(REF DART SPEC M5052H32S.125)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) ALL DIMENSIONS ARE IN INCHES

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WITHOUT NOTICE
WORK ORDER
NO. 4385

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